		ASAl				in the second		lex
Work Order ID 100249 — \ April-22-13 12:51:53 PM		*100	1249*		P	Salt	gan	Page 1
Item ID: D4021-5 Revision ID: Item Name: Blanking Plate Start Date: 4/22/13 Start Qty: 20.0 Required Date: 5/03/13 Req'd Qty: 20.0 Reference:	//	Accept )* )*	*N900 Cust Item I Customer:			Setup Starr	*NS	S1* S2*
Approvals: Process Plan: MC5	Date: 13-04-	24 Tooling:	D	ate:		Run Star		R1*
QC:	Date:	SPC (Y/N):	D	ate:		Stop	*NI	R2*
Sequence ID/ Operation Work Center ID Description		Set Up/ Run Hours	Tool ID	Tool # Pla	n Accept de Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr Revision Nbr								
D4021 B		0.00						
*100*		0.00			200			1.1.1.1
Waterjet Memo		0.00			20	Ø		13.05.20
Prog Rev Dwg Rev	er dwg D4021 PEV B PEV B s required							
110 QC2- Inspect parts of	ff machine FAI/FAIB	0.00						
*110* QC Memo Quality Control		0.00			20	ø		13.05.29

DQA: Date: WORK ORDER NON-CONFORMANCE / UPDATE NCR: Yes / No QA Closed: Date: DISPOSITION AGAINST DEPARTMENT/PROCESS Work Order: Water Jet Engineering Skid-tube Crosstube Rework Machining Prod. Eng. Coor. Quality Small Fab Part No. Scrap Thermoforming Rec/Store/Packaging **Finishing** Use-as-is Work Order Update Large Fab Composite Supplier NCR No. Description of work order update Action Sign & Initial Root Date Verification QC Inspector Qty or Non-conformance Chief Eng Description Step Cause Date Doc/Data Equip/Tooling Operator Material Setup

Other

Unapproved				1	
11			FAULT CATEGORY		
Landi	ng Gear	General	1		_
	Bending	Bend	Grain	Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance	Temperature/Cure
	Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect	Weld
	Crushed/Crimped	Burrs	Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled
	Cuffs	Contamination	Maintenance	Part Moved	
	Heat Treat	Countersink	Mislabeled	Positioned Wrong	_
	Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge	Other
	Ripples in Bend	Drill Holes	Offset	1	
	Torque Waves in Extrusion	Drawing	Out of Calibration		
	Turning Sequence	Finish	Out of Sequence		
	Wave/Twist in Tube	Folio	Outside Dimensions		

Other Process Supplier Training \*100249\*

Page 2

April-22-13 12:51:53 PM

Item ID:

Revision ID:

D4021-5

Blanking Plate

Accept

\*N900040100\*

Setup Start

Stop

Item Name: Start Date:

4/22/13

Start Oty: 20.00 Req'd Qty: 20.00 \*20\*

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Start Run

Qty

QC:

Required Date: 5/03/13

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

120

Operation Description

QC8- Inspect parts - second check

White Gloss(Ref.4.3.5.2) per QSI005 4.3-Steel

Set Up/ **Run Hours**  Tool ID

Tool # Plan Code Accept Qty

Reject Reject

Insp. Number Stamp

\*120\*

Memo

Memo

0.00

20

Quality Control

130

\*120\*

Powdercoat

Powder Coating

m(2348)

QC3- Inspect Part Finish

Memo

Black Sandlex. For austom backet.

One Start (ime: 7:30 2)

Temp : 3200F

One Frish Time: 8:00

2 \$ B.6.5.

135

\*135\*

Quality Control

0.00

											DQA:	Date	e:
NCR:	Yes	/ No				WORK ORDER NON-	co	NFORM	MANCE / UP	DATE			
											QA Closed:	Date	e:
Work Ord	0.51					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
WORK Ordi	er				<del></del>	Rework			Skid-tube	Crosstube	1	Water Jet	Engineering
Part I	No.					Scrap	-		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
20/27/05/02						Use-as-is		100	noforming	Finishing	-	re/Packaging	Other
NCR I	No.					Work Order Update			Large Fab	Composite		Supplier	
							_				I ai a		T
Root	- 1	2	-			ption of work order update		Initial	1,000	tion	Sign &	V- :6	001
Cause	$\dashv$	Date	Step	Qty		or Non-conformance	Ci	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data	Н												
Equip/Tooling	Н												
Operator	Н												
Material	Н												
Setup	Н												
Other	Щ												
Process	Ш			1									ľ
Supplier	Ц			1 1									
Training	Ш												
Unapproved													
							FAU	LT CATE	GORY ·				
Landi						General		1		_	1	ř.	_
		Bending				Bend		Grain			Ovalized		Pressure/Forced
	Ш	Centre N	ot Conce	ntric to C	)/S	BOM/Route		Hardwa			Over/Under		Temperature/Cure
	Ш	Cracks				Broken/Damaged	L	Inspecti	ion Incomplete		Part Incorred	ct	Weld
		Crushed/	Crimped			Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
16		Cuffs				Contamination		Mainte	enance		Part Moved		
		Heat Trea	at			Countersink		Mislabe	eled		Positioned V	Vrong	
Inspection Strip in Tube				Cut Too Short	Misread			Power Loss/	Surge	Other			

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 100249

\*100249\*

Page 3

April-22-13 12:51:53 PM

Required Date: 5/03/13

Item ID:

D4021-5

4/22/13

Accept

\*N900040100\*

Setup Start

**Revision ID:** 

Start Date:

Item Name:

Blanking Plate

Start Qty: 20.00 Req'd Qty: 20.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Reject

Qty

Accept

Qty

Number Stamp

QC:

Date:

SPC (Y/N):

Set Up/

Date:

Tool # Plan

Code

Stop

Reject

Insp.

Sequence ID/

Work Center ID

140

\*140\*

Packaging

Operation Description

Identify as per dwg & Stock Location: D40 30 - odd

0.00

**Run Hours** 

Tool ID

2 d Bl 13-6-5.

Packaging

150

\*150\*

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

Memo

0.00

MLJ 13-06-07

NCR: Y	'es	/ No				WORK ORDER NON-O	CON	VFORM	MANCE / UPI	DATE			
											QA Closed:	Date	:
Work Order:  Part No  NCR No					DISPOSITION  Rework  Scrap  Use-as-is  Work Order Update			Skid-tube  Machining noforming  Large Fab	-	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other		
Root	$\neg$				Descri	ption of work order update	1	nitial	Act	ion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved			i.	٨					e e e e e e e e e e e e e e e e e e e	T W			
						F	AUL	T CATE	GORY				
Landi	ng G	iear				General					1		7
		Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspection Ripples in	Crimped it n Strip in i Bend	Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instruct Mainte Mislabe Misread Offset	on Incomplete ions Incomplete/U nance led	Jnclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned W Power Loss/S	ssing /rong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	Н	Torque W			n	Drawing	$\vdash$		Calibration				
Turning Sequence			Finish	inish Out of Sequence									

Outside Dimensions

DQA:

Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio

April-22-13 12:51:53 PM

Work Order ID:

100249

Parent Item:

D4021-5

Parent Item Name:

Blanking Plate

Start Date: 4/22/13

Required Date: 5/03/13

Start Qty: 20.00

Required Qty: 20.00

Comments:

36 118.05

IPP RevA: new issue DD 09.11.25 verified by:EC IPP Rev:B as per dwg REV.A DD 10.02.22 verified by:EC IPP Rev:C as per dwg revB DD 10.04.20 verified by:EC

124428

124572

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 304/316 Sheet .063	THE PARTY	Purchased	No			100	sf	295.0214	0.0622	1.309474 .3/	Ae1	Mel.	13.05.2
				Location		Loc Qty	Lo	e Code					1134-4
				MAT020		295.0213688							
				12224	5	0.1713688							
1 50				12313	6	140.8			72-2				

NCR: Y	es/	/ No				WORK ORDER NON-	COI	VFORN	ANCE / UPI	DATE	QA Closed:	Date	
Work Orde	۱٥.					DISPOSITION  Rework  Scrap  Use-as-is		Therm	Skid-tube Machining	AGAINST DE  Crosstube  Small Fab  Finishing	PARTMENT,	/PROCESS  Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N Root	NO				1	Work Order Updateiption of work order update		nitial	Large FabAct		Sign &	Supplier	
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved				12.									
						F	AUL	T CATE	ORY				
Landi	ng G	Gear				General						72	
		Bending Centre No Cracks Crushed/c Cuffs Heat Trea Inspection Ripples in Torque W	Crimped it n Strip in i Bend	Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instructi Mainte Mislabe Misread Offset Out of C	on Incomplete ions Incomplete/L nance led Galibration	Jnclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct sssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
Turning Sequence			Finish		Out of S	equence							

Outside Dimensions

DQA:

Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

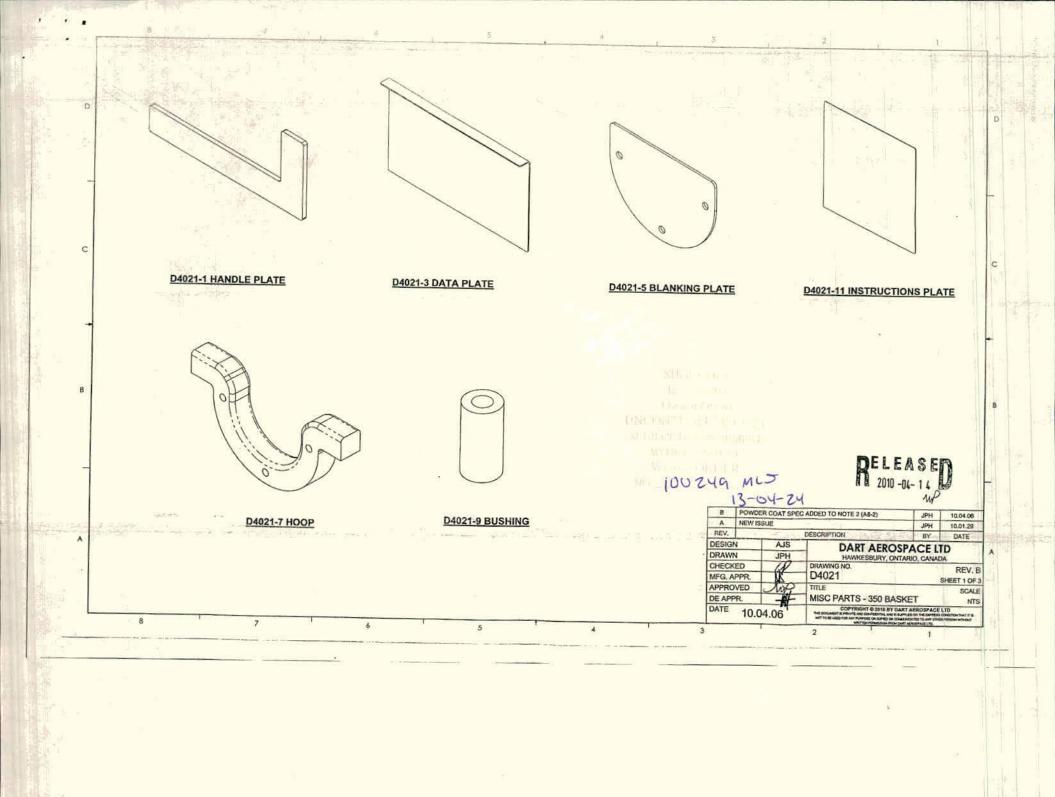
Folio

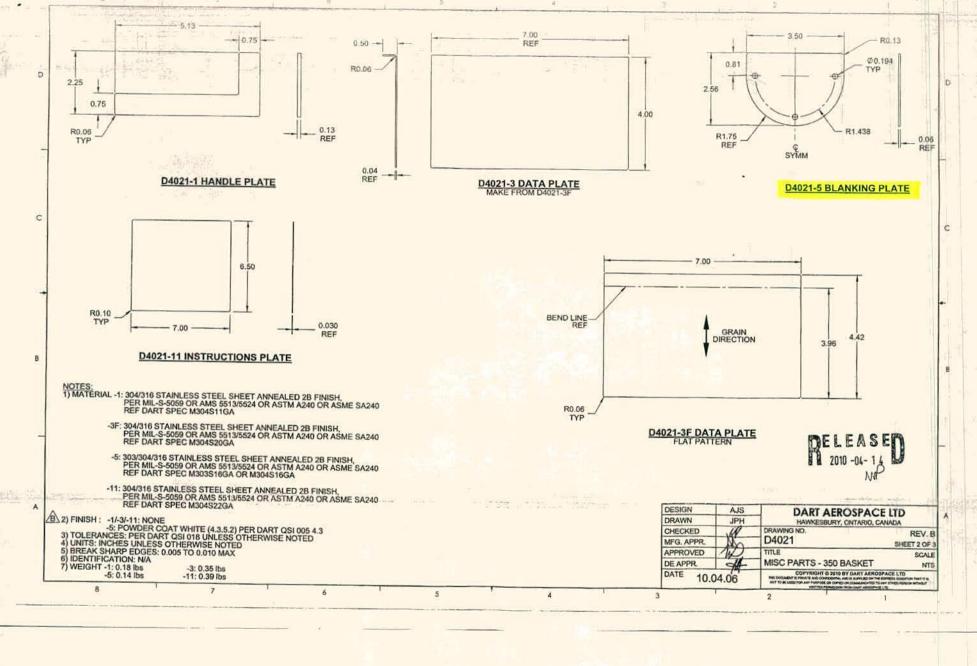
DART AEROSPACE LTD	Work Order:	100249
Description: Blanking Plate	Part Number:	D4021-5
Inspection Dwg: D4021 Rev: B		Page 1 of 1

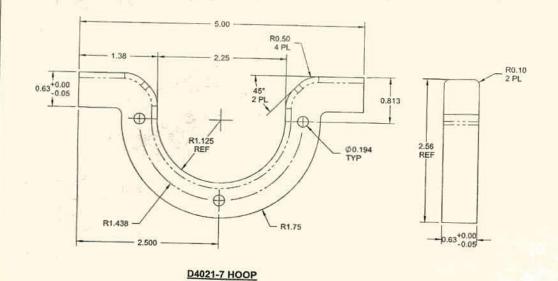
## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.194	+0.005/-0.001	3.491	0.198		V	JKM-01
3.50	+/-0.030	3.491	V		V	UKm-01
2.56	+/-0.030	2.559			V	
0.81	+/-0.030	0.81	V.	J. 1	V	
0.060	+/-0.010	0.058			V	
Age - Age						
				4	Glacial	
		LICE TIME			2.44	
		No. of the last				
a cella antica?	Tarted Page 1				- 48	
	dail =		1 77 1	734	p 14	
E F F F				200		
HAMPAN DE M	mingers) . As					
Rife to the Pvin		15/5/6	THE STATE			
				Mary S.		
Novi I a Till 1	76	17.77.15	-Y 1 [1-5]			ATA S
		The state of			ALBERT THE	
191						
THE NEW YORK		ш			Per Survey	
			Sate of the same o			Yfev
N TO THE				F = 1	III IV	116
Street L				-		
					Ya.	
		Whi.	3.0			
					91	
					1,000	
			040			
easured by: Ae	MA	Audited by:	,27		Preliminary A	pproval:
Date: 131	05.29	Date:	13.55	0		Date:
	nange w Issue				Revise	d by Approve







Ø0.191

D4021-9 BUSHING

DESIGN	AJS	DART AEROSPACE LTD					
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA					
CHECKED	w	DRAWING NO.	REV. B				
MFG. APPR.	W	D4021	SHEET 3 OF 3				
APPROVED	AMP.	TITLE	SCALE				
DE APPR.	1	MISC PARTS - 350 BASKET	NTS				
DATE 10.0	4.06	COPTRIGHT © 2010 BY DART AEROSPACE LTD  THE ORDERS'S STREET OF THE FEBRUAR OF BUTTON OF THE COPPED BENDOOD THAT IS  HET TO BE USED FOR HEY PAPER OR DOPED OF COMMENTED OF THE PAPER HETCH.  HET THE SET OF THE PAPER OF THE PAPER HETCH.  HETCH THE THE THE THE THE THE THE THE THE TH					

NOTES: 1) MATERIAL-7: 304/316 STAINLESS STEEL BAR, PER ASTM A276 REF DART SPEC M304B

-9: 304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 REF DART SPEC M304R

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT -7: 0.80 lbs
-9: 0.02 lbs

8 .

5